

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026106**Date Inspected:** 01-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 13AW, 13BW, 13CW**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

HEAVY DOCK

This QA inspector monitored testing of magnetic particle yokes used by ZPMC, and AB/F for testing of OBG welds with Interzink 22 primer located in contact area. Yokes were tested using a 10lb.+ steel plate with Interzink 22 primer with a DFT of 2 to 4 mils.

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This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC and AB/F personnel. This QA inspector generated an UT report for this date. The segments are identified as 14W and 13AE. The weld designations reviewed are as follows.

SEG3020AL-072, 074

SEG3007Y-067, 413, 415

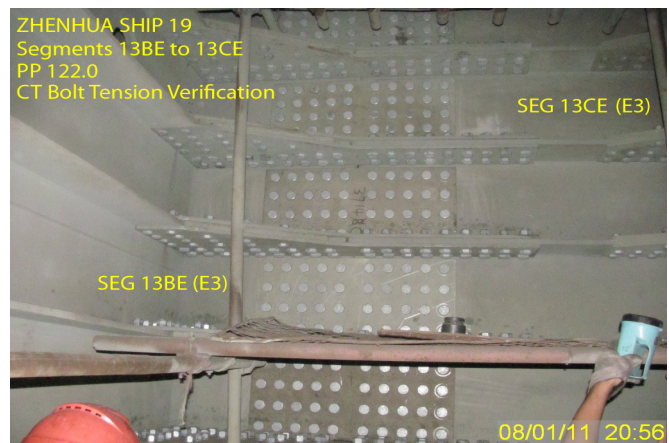
This QA inspector performed High Strength Bolt Tension Verification of approximately 10% of an area that has been previously tested and accepted by ZPMC and AB/F personnel. This QA inspector verified the following bolt size, tension, and location:

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M22x80 DHGM220140 380N LD Ribs at E3 OBG 13E PP120~PP123.5
M22x85 DHGM220121 393N LD Ribs at E3 OBG 13E PP120~PP123.5
M27x95 DHGM270034 640N LD Ribs at E3 OBG 13E PP120~PP123.5
M24x75 DHGM240115 460N LD to DP Dia. at E3 and E4 PP117.5~PP120
M24x90 DHGM240123 467N LD to DP Dia. at E3 and E4 PP117.5~PP120
M24x100 DHGM240125 440N LD to DP Dia. at E3 and E4 PP117.5~PP120
M24x120 DHGM240127 430N LD to DP Dia. at E3 and E4 PP117.5~PP120

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
